

(12) UK Patent Application (19) GB (11) 2 031 787 A

- (21) Application No 7903594
 (22) Date of filing
 1 Feb 1979
 (23) Claims filed
 1 Feb 1979
 (30) Priority data
 (31) 952496
 (32) 18 Oct 1978
 (33) United States of America
 (US)
 (43) Application published
 30 Apr 1980
 (51) INT CL³ B29C 1/16
 B29F 1/00
 B29G 3/00
 (52) Domestic classification
 B5A 1R314C1X
 1R314C2X 1R322 T14D
 (56) Documents cited
 GB 1309009
 GB 1215821
 GB 1071199
 GB 1058415
 GB 998665
 GB 912866
 GB 803653

- GB 771846
 GB 703829
 GB 536568
 (58) Field of search
 B5A
 (71) Applicant
 Hull Corporation
 Hatboro
 Pennsylvania 19040
 United States of
 America
 (72) Inventor
 John A Smith
 (74) Agents
 Potts Kerr & Co
 (54) Platen type molding press
 (57) In a molding press having fixed
 10 and movable 18 platens for
 mounting mold halves 21, 20, the
 movable platen is connected
 through thrust rods 60 and a thrust
 plate 56 to the movable component
 of an hydraulic piston-cylinder drive

unit 52 the fixed component of which is attached to a fixed base 14. A high pressure piston-cylinder mold clamping unit 24 of the pancake type interengages the movable platen and a pancake cylinder support plate 22 mounted for movement along the thrust rods and arranged for abutment by the thrust plate. The pancake cylinder support plate and fixed base are joined together by toggle joints 36 operated by a piston-cylinder locking unit 42 supported pivotally on arms 46 extending pivotally from the pancake cylinder support plate and fixed base. The drive unit thus is arranged in parallel with the series arrangement of the toggle joints and mold clamping unit.

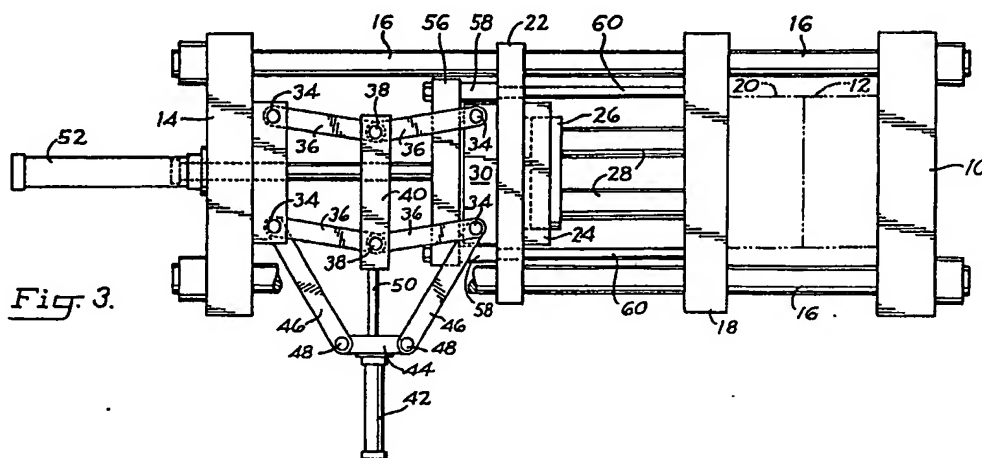


Fig. 3.

03594

-1 FEB 1979

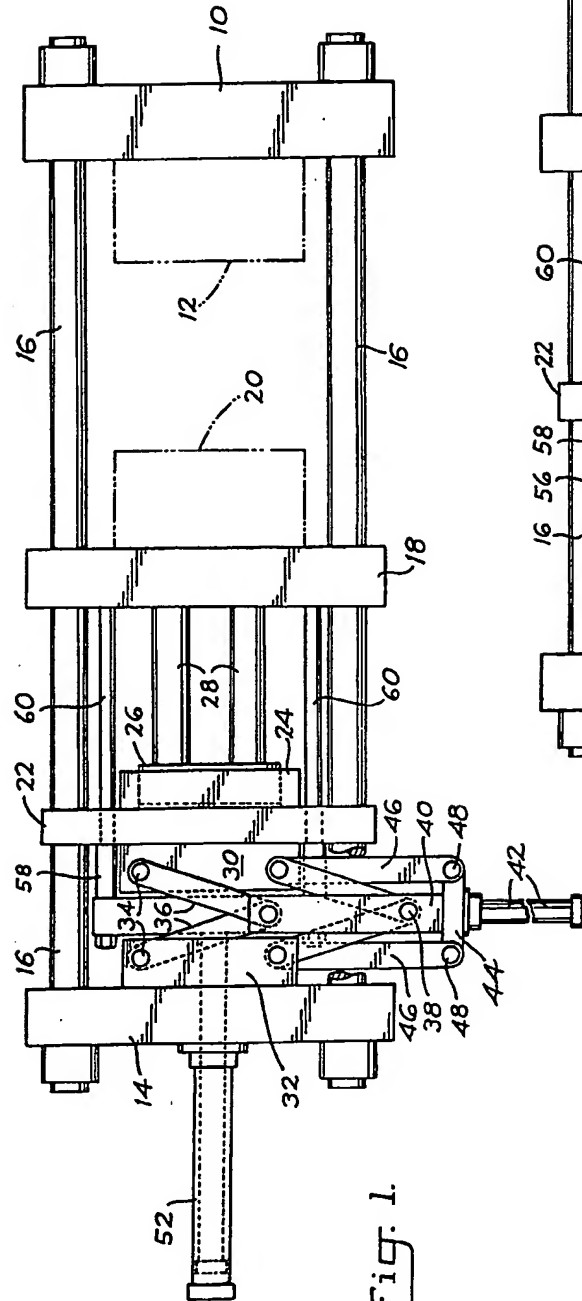


Fig. 1.

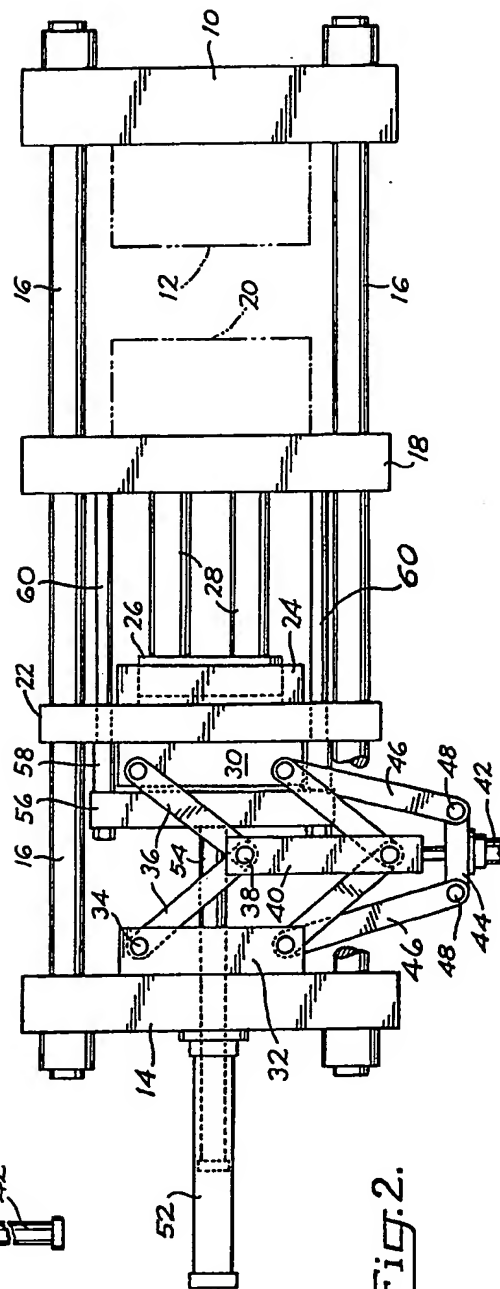
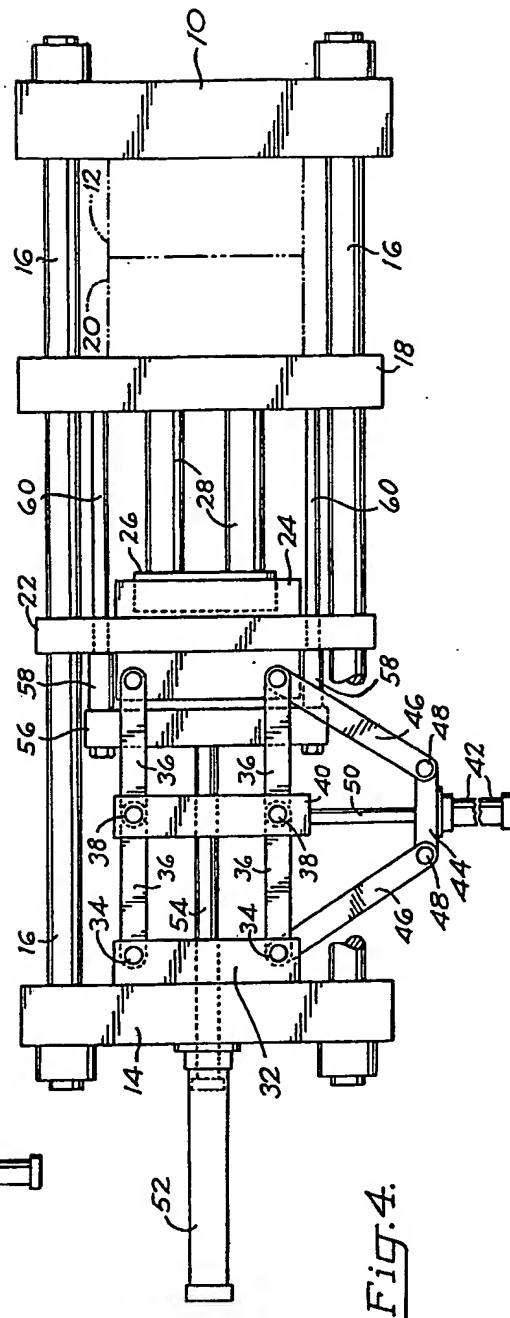
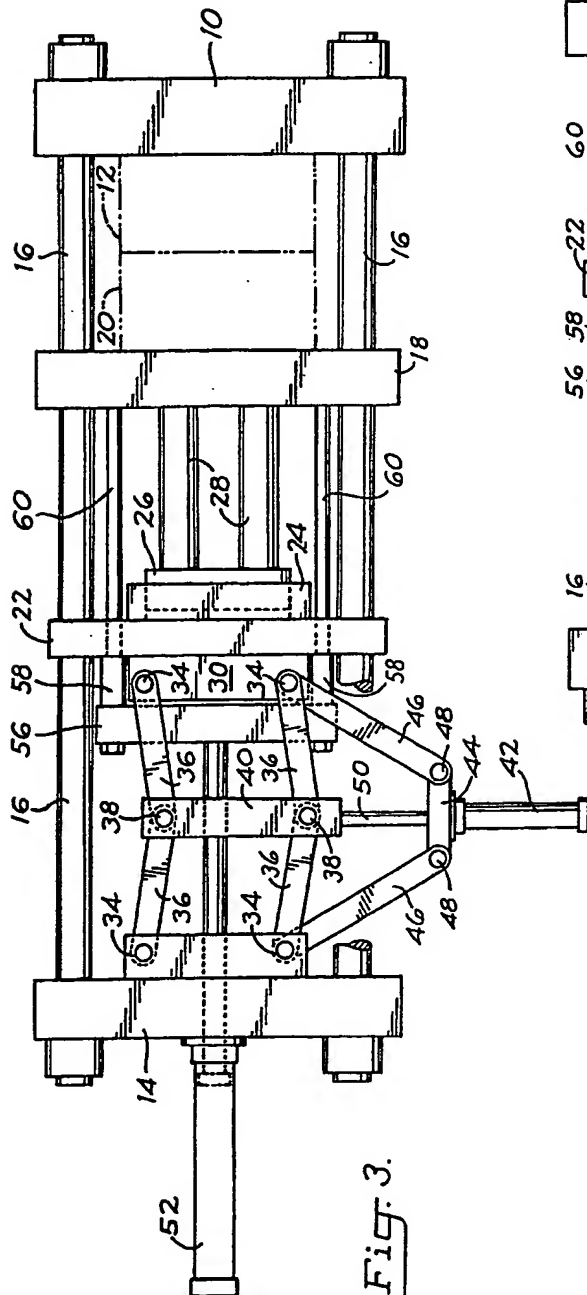


Fig. 2.

03594

-1 FEB 1979



SPECIFICATION

Platen type molding press

5 This invention relates to molding presses, and more particularly to mechanism for opening and closing the molds of a molding press.

10 In transfer and injection molding of synthetic thermosetting and thermoplastic resins, rubber and other elastomers, die cast and other materials, the presses must furnish a clamping force greater than the force created by the transferring or injecting of materials into the closed mold. The created force depends upon
15 the size of the mold, the number of mold cavities, the material being transferred or injected and the transfer or injection pressure being used. These pressures created within the mold, trying to force it open, vary from a few tons to several thousand tons.

20 Pressures of these magnitudes have been accommodated in molding presses heretofore by mold closing mechanisms the structures of which present certain limitations and disadvantages. Typical of these prior structures is a molding press in which the movable mold platen is moved between open and closed position by toggle joints operated by a piston-cylinder unit and pivotally interconnecting a
30 fixed base and a movable pancake cylinder support plate. A pancake type clamping cylinder interengages its support plate and the movable mold platen to provide final high pressure for closing the mold. This structural arrangement seriously limits the extent of opening of the mold, thereby rendering difficult and more time consuming the clearing and maintenance of the mold sections. It also requires the piston-cylinder unit for the
40 toggle joints to provide considerable power, and therefore the closing movement of the mold is correspondingly slowed. This is reflected in a longer molding cycle.

45 In its basic concept, the platen type molding press of this invention utilizes an extensible platen drive mechanism in parallel with the series arrangement of extensible locking and mold clamping mechanisms.

50 It is by virtue of the foregoing basic concept that the principal objective of this invention is achieved; namely, to overcome the aforementioned disadvantages and limitations of prior mold opening and closing mechanisms.

55 Another objective of this invention is the provision in a platen type molding press mold opening and closing mechanism which enables opening of the mold to a substantially greater degree than has been afforded heretofore.

60 Still another objective of this invention is the provision in a platen type molding press mold opening and closing mechanism which affords considerably faster movement of the movable mold section than has been afforded
65 heretofore.

A further objective of this invention is the provision in a platen type molding press of mold opening and closing mechanism provided with maximum mold protection control.

70 A still further objective of this invention is the provision of mold opening and closing mechanism of the class described which is of simplified construction and is readily adaptable for integration with conventional platen
75 type molding presses.

The foregoing and other objects and advantages of this invention will appear from the following detailed description, taken in connection with the accompanying drawings of a preferred embodiment.

80 Figs. 1, 2, 3, and 4 are fragmentary views in side elevation of a platen type molding press incorporating mold opening and closing mechanism embodying the features of this
85 invention, Fig. 1 showing the component arrangement with the molds fully opened, and Figs. 2, 3 and 4 showing the component arrangements as the mold sections are moved progressively to the fully closed position of
90 Fig. 4.

The drawings illustrate certain basic components of a conventional platen type molding press with which the mold opening and closing mechanism of this invention may be integrated. Thus, there is shown a fixed platen
95 adapted to support a fixed mold section 12, and a stationary base 14 spaced longitudinally from but adjustable toward and away from the fixed platen. A plurality of elongated guide
100 rods 16 are supported by and extend between the fixed platen and stationary base. As illustrated, there are four such guide rods arranged adjacent the four corners of the rectangular fixed platen and stationary base.

105 A movable platen 18 is provided with transverse openings for the reception of the guide rods which thus support the movable platen for longitudinal movement toward and away from the fixed platen. The movable platen is
110 arranged to mount a movable mold section 20 for cooperative association with the fixed mold section.

Located between the movable platen and the stationary base and supported by the
115 guide rods for longitudinal movement thereon is a clamp cylinder support plate 22. On the side of this plate facing the movable platen is secured the cylinder 24 of an extensible piston-cylinder mold clamping unit. As illustrated, this unit is of the pancake cylinder
120 type. This piston 26 projects from the cylinder and a plurality of piston rods 28 extend from the piston into attached engagement with the movable platen.

125 On the opposite face of the support plate 22, i.e. the face confronting the stationary base 14, there is secured a vertically elongated bracket 30. A pair of such brackets 32 are mounted in laterally spaced relationship
130 on the confronting face of the stationary base.

These brackets 30 and 32 serve to support pivot shafts 34 which mount the outer ends of elongated bars 36 which are arranged in pairs to form a plurality of toggle joints. The inner, lapped ends of the bars of each pair are connected together pivotally by a pivot shaft 38 which extends between a pair of laterally spaced connector plates 40.

In the embodiment illustrated, there are upper and lower toggle joints interconnected by the plates 40 for simultaneous operation by an extensible hydraulic piston-cylinder unit. As illustrated, the cylinder 42 of the unit is secured to a base 44 supported by a pair of arms 46 which are secured at one end to the base 44 by means of pivot shafts 48. The opposite end of one of the arms is secured to a pivot shaft 34 carried by the bracket 32 on the stationary base 14. The corresponding end of the other arm is secured to the pivot shaft 34 carried by the bracket 30 on the support plate 22. The projecting end of the piston rod 50 associated with the cylinder 42 is connected to the pivot shaft 38 carried by the plates 40 and joining the lapped ends of the lower toggle joint bars 36.

The foregoing structural arrangement comprises the essential components of a typical form of molding press. The movable platen is moved between open and closed positions, by appropriate application of hydraulic fluid under pressure to the toggle cylinder 42. This cylinder performs the dual function of a platen drive cylinder and a mold locking cylinder. Thus, when the piston rod of the toggle cylinder has been extended to the mold locking position illustrated in Fig. 4, wherein the toggle joints are fully straightened between the stationary base 14 and the support plate 22, the mold section 20 carried by the movable platen will have been brought into closed position against the confronting surface of the mold section 12 carried by the fixed platen. High clamping pressure then is supplied to the mold by application of high pressure hydraulic fluid to the clamping cylinder 24.

Opening of the mold is achieved by relieving the high pressure hydraulic fluid in the clamping cylinder and then applying high pressure hydraulic fluid to the toggle cylinder 42 in the direction to retract the associated piston rod 50 and collapse the toggle joints. However, the extent of such collapse of the toggle joints is limited substantially to the arrangement illustrated in Fig. 2. This limitation severely restricts the degree of opening of the mold, as evidenced by a comparison of Figs. 1 and 2.

In accordance with this invention, means is provided for moving the movable mold section 20 between closed, but unclamped position relative to the fixed mold section 12, and the fully retracted position of Fig. 1. In the embodiment illustrated, this means is provided by an extensible hydraulic piston-cyl-

inder platen drive unit. One component of the unit, the elongated cylinder 52 in the embodiment illustrated, is secured at the piston rod end thereof to the stationary base 14. The piston rod 54 of the unit extends freely through an opening in the base 14 and is connected at its outer end to a thrust plate 56. Secured to the thrust plate and extending therefrom freely through aligned openings in the support plate 22 and stabilizer bosses 58, are a plurality of elongated thrust rods 60. The forward ends of the thrust rods are secured to the movable platen 18. Thus, the platen drive unit 52, 54 extends between the stationary base 14 and movable platen 18 in parallel with the series-connected assembly of clamping cylinder 24-28 and toggle joints operated by toggle cylinder 42.

It is to be noted, from a comparison of Figs. 1 and 2 that the platen drive cylinder 52 enables complete collapse of the toggle joints and correspondingly greater separation of the movable mold from the fixed mold, in the fully opened condition of the press. This greater "daylight" condition between the fixed and movable mold sections greatly facilitates clearing of mold pieces from the mold and also maintenance and repair of the mold components.

The operation of the press described hereinbefore is as follows: Assuming the press components are in the positions illustrated in Fig. 1, i.e. in the fully opened condition of the press, hydraulic pressure is removed from the pancake cylinder 24 and toggle cylinder 42 and hydraulic pressure is applied to the platen drive cylinder 52 in the direction to extend the piston rod 54 toward the right in the drawings. The thrust plate 56 and thrust rods 58, together with the attached movable platen 18, are moved quickly toward the right to the position illustrated in Fig. 3: In this position the movable mold section 20 is brought into positive, but low pressure abutment with the fixed mold section 12.

During movement of the thrust plate 56 toward the right, it abuts the bosses 58 associated with the pancake cylinder support plate 22, and thus moves the latter and pancake cylinder with it toward the right.

The mold sections having been closed under the relatively low pressure of the platen drive cylinder 52, hydraulic pressure is applied to the toggle cylinder 42 in the direction to extend the piston rod 50 and move the toggle joints from the slightly collapsed condition of Fig. 3 to the straight, locked condition of Fig. 4. For this purpose the magnitude of hydraulic pressure required for the toggle cylinder need only be sufficient to move the toggle joints to the locking position of Fig. 4.

With the toggle joints held in locking position, the pancake cylinder then is activated by high hydraulic pressure to apply high clamping force to the movable platen and hence to

the movable mold section. This clamping force is maintained during transfer or injection of appropriate material into the cavities of the mold.

- 5 When it is desired to open the press, the high clamping pressure is removed from the pancake cylinder and hydraulic pressure is applied to the toggle cylinder 42 in the direction to retract the toggle joints from the
10 locked position of Fig. 4 to the partially collapsed condition for Fig. 3, after which the retracting pressure may be removed. Hydraulic pressure then is applied to the platen drive cylinder 52 in the direction to retract the
15 piston rod 54 toward the left, until the press components have returned to the positions illustrated in Fig. 1.

- It will be appreciated that since the platen drive cylinder is arranged in parallel with the
20 series arrangement of the pancake cylinder and toggle joints operated by the toggle cylinder, opening and closing of the press is achieved by the platen drive cylinder independently of the operation of the pancake cylinder and toggle cylinder. However, in the event
25 of malfunctioning of the platen drive cylinder, the press still may be operated under emergency condition by utilizing the toggle cylinder as a platen drive cylinder, as in the
30 manner of the prior art described hereinbefore.

- Of consideration importance in the present invention is the increased speed with which the mold may be opened and closed by
35 operation of the platen drive cylinder 52. These linear movements of the platen drive cylinder are faster than the movements of the toggle joints by operation of the toggle cylinder 42. Accordingly, the molding time cycle
40 and cost of production are correspondingly decreased.

- Also of importance in the present invention is the minimizing of the size of the toggle cylinder 42 and platen drive cylinder 52 and
45 the corresponding volume of hydraulic fluid required for their operation. This minimizes the size and cost of hydraulic pumps and electric drive motors. It has been found that these factors contribute beneficially to reducing the electric horsepower requirement by
50 about one half.

- Further, since the platen drive cylinder functions to close the mold prior to actuating the toggle cylinder and the clamping cylinder,
55 maximum mold protection control with minimum timing mechanism is achieved.

- It will be apparent to those skilled in the art that various changes may be made in the size, shape, type, number and arrangement of
60 parts described hereinbefore. For example, the connections of the hydraulic piston-cylinder units to the associated components may be reversed. Extensible power drive mechanisms, such as electrically or hydraulically driven rack
65 and pinion mechanisms, may replace the hy-

draulic piston-cylinder units illustrated, although the latter are preferred for their versatility, power capabilities and speed of operation. The thrust plate 56 may be supported by
70 the guide rods 16 for longitudinal reciprocation. The foregoing and other changes may be made, as desired, without departing from the spirit of this invention.

75 CLAIMS

1. A platen type molding press comprising fixed and movable platens for moving mold components, the movable platen being mounted on guide rods extending between
80 the fixed platen and a stationary base and an extensible platen drive mechanism interengaging the stationary base and movable platen and operable to move the latter relative to the fixed platen and a series-connected assembly
85 of extensible locking mechanism and extensible mold clamping mechanism connected in parallel with the platen driven mechanism.

2. A press as claimed in claim 1, in which the extensible platen drive mechanism, locking mechanism and clamping mechanism
90 each includes an extensible hydraulic piston-cylinder unit.

3. A press as claimed in claim 1, in which the extensible platen drive mechanism comprises piston-cylinder platen drive unit and the extensible mold clamping mechanism comprises piston-cylinder mold clamping unit having one end engaging the movable platen and an extensible piston-cylinder locking unit inter-
95 engages the stationary base and the end of the clamping unit opposite the platen-engaging end.

4. A press as claimed in claim 3, in which one of the piston or cylinder of the platen drive unit is secured to the stationary base, a movable thrust member engages the other of the piston or cylinder of the platen drive unit and a plurality of thrust rods on the thrust member engage the movable platen.
105

5. A press as claimed in claim 4, in which a clamping unit support member is mounted on the thrust rods for movement thereon and supports the end of the clamping unit opposite the end engaging the movable platen.
110

6. A press as claimed in claim 5, in which the locking unit includes a toggle joint the outer ends of which are connected pivotally one to the stationary base and the other to the clamping unit support member, the intermediate joint being connected pivotally to one of the piston or cylinder of the locking unit and support arms pivotally interconnect the other of the piston or cylinder of the locking unit and the stationary base and clamping unit
115 support member.

7. A press as claimed in claim 3, in which the piston-cylinder units are of the hydraulic type, one of the piston or cylinder of the platen-drive unit is secured to the stationary base, a movable thrust member engages the
130

- other of the piston or cylinder of the platen drive unit, a plurality of thrust rods on the thrust member engages the movable platen, a clamping unit support member is mounted on
- 5 the thrust rod for movement thereon and supports the end of the clamping unit opposite the end engaging the movable platen and the locking unit includes a toggle joint the outer ends of which are connected pivotally
- 10 one to the stationary base and the other to the clamping unit support member, the intermediate joint being connected pivotally to one of the piston or cylinder of the locking unit and support arms pivotally interconnect the other
- 15 of the piston or cylinder of the locking unit and the stationary base and clamping unit support member.

8. A platen type molding press constructed and arranged to operate substantially
- 20 as herein described with reference to and as illustrated in the accompanying drawings.

Printed for Her Majesty's Stationery Office
by Burgess & Son (Abingdon) Ltd.—1980.
Published at The Patent Office, 25 Southampton Buildings,
London, WC2A 1AY, from which copies may be obtained.

BEST AVAILABLE COPY